

# Work Order ID 82804

April-10-12 10:38:52 AM

**\*82804\***

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Item ID: D206-802-027

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Passenger Door Opener Installation, LH

Stop **\*NS2\***

Start Date: 10/04/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-2	A								

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-027 CHG001

*JB S. Schubert* *MLJ 12-6-6*

105

Pick Kit

0.00

**\*105\***

Packaging

Memo

0.00

Packaging

*12/06/06 JP*

110

QC4- 100% Inspect kits for completeness

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*S. Schubert*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82804

**\*82804\***

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Item ID: D206-802-027

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Passenger Door Opener Installation, LH

Stop **\*NS2\***

Start Date: 10/04/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-027								
	Location: _____								
	PPP rev: <u>DAFJ</u>								
130									
<b>*130*</b>	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

1 \_\_\_\_\_ Sum 12/00/07

12/6/8 JH

MLC 12/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82804

\*82804\*

Parent Item: D206-802-027

\*D206-802-027\*

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-17 *D3552-17* Door Prop		Manufactured	No			105	Each	11.0000	0	1			
-------------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST272	5	
-------	---	--

64338	4	
-------	---	--

65120	1	
-------	---	--

ST276	6	
-------	---	--

69670	6	
-------	---	--

D3622-5 *D3622-5* Ball Stud		Manufactured	No			105	Each	14.0000	2	2			
-----------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST058	14	
-------	----	--

80406	14	
-------	----	--

D4110-1 *D4110-1* Door Doubler, LH		Manufactured	No			105	Each	3.0000	0	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST129	3	
-------	---	--

64354	3	
-------	---	--

D4112-1 *D4112-1* Aft Sill Doubler		Manufactured	No			105	Each	8.0000	0	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST130	8	
-------	---	--

72212	8	
-------	---	--

72212 S

12/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 82804

\*82804\*

Parent Item: D206-802-027

\*D206-802-027\*

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

CR3242-4-2

Purchased

No

105

Each

202.0000

5

✓

\*CR3242-4-2\*

Rivet

\*\*

JB

## Location

## Loc Qty

## Loc Code

ST331

202

116583

2

117423

100

120717

100

2x116583 S

3x120717 S

MS20426AD4-5

Purchased

No

105

Each

5,010.000

4

4

✓

\*MS20426AD4-5\*

Rivet

\*\*

JB

## Location

## Loc Qty

## Loc Code

ST317

5010

6874

5010

6874 S

MS20600-AD4W2

Purchased

No

105

Each

277.0000

5

5

✓

\*MS20600-AD4W2\*

Rivet

\*\*

JB

12/06/06

## Location

## Loc Qty

## Loc Code

ST321

277

116391

5

116471

4

116805

4

117601

1

117885

10

119638

3

120142

150

121011

100

120142 S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 82804

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Parent Item: D206-802-027

\*D206-802-027\*

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

22.0000

\*MS21073L5\*  
nut plate

\*\*

## Location

## Loc Qty

## Loc Code

ST302

12

117395

12

ST303

10

120986

10

NAS1149C0532R

Purchased

No

105

Each

401.0000

\*NAS1149C0532R\*  
WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST297

401

116373

1

116513

53

119736

347

NAS1149C0563R

Purchased

No

105

Each

404.0000

\*NAS1149C0563R\*  
Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST296

200

120422

200

ST297

204

116391

4

117460

200

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

## 5.3 D206-802-027/-028 Passenger Door opener Kits

Qty -027	Qty -028	Part Number	Description
		D206-802-027	PASSENGER DOOR OPENER KIT, LH
		D206-802-028	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
2	2	D3622-5	BALL STUD
1	1	D4110-1	DOOR DOUBLER, LH
	1	D4110-2	DOOR DOUBLER, RH
1	1	D4112-1	AFT SILL DOUBLER
5	5	CR3242-4-2	RIVET
4	4	MS20426AD4-5	RIVET
5	5	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

## 5.4 D206-802-033 Baggage Door Opener Kit, Metal

Qty -033	Part Number	Description
	D206-802-033	BAGGAGE DOOR OPENER KIT, METAL
1	D3552-19	DOOR PROP
1	D4109-043	DOUBLER ASSEMBLY
1	D4113-041	DOUBLER ASSEMBLY, BAGGAGE DOOR
4	80-004-2-6	INSERT
8	CR3213-4-2	RIVET
4	MS27039C1-06	SCREW
4	NAS1149C0363R	WASHER